

Date: Thursday, 20/11/2008 3:35:31 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TIRE AND RIM ASSEMBLY
Job Number : 43628	
Estimate Number : 11156	
P.O. Number :	Part Number : D32339
This Issue : 20/11/2008 S.O. No. :	Drawing Number : D3233 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 37649	Material :
Written By :	Due Date : 21/12/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JLD 08.11.21</u>	
Comment : Est. A 05.03.03 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: 7658C20811/24

For D3233-9 Tire and Rim Assembly P/N: 8353T74

Possible Supplier: McMaster-Carr

(10)

Product Specification sheet is required

2.0	8353T74	TIRE & RIM
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Tire & Rim Assembly

3.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECKS65127410

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive and Inspect for transit damage

Ensure Product Specification sheet is attached

Identify and Stock

Location: 471P8/11/26 (10)

5.0	QC21	FINAL INSPECTION/W/O RELEASE
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08/11/28 JLD**Comment:** FINAL INSPECTION/W/O RELEASE

Job Completion

mf 08-11-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

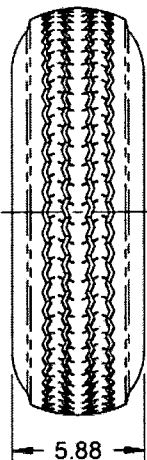
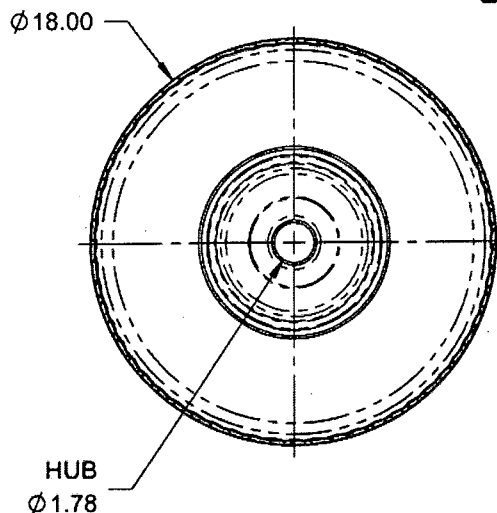
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



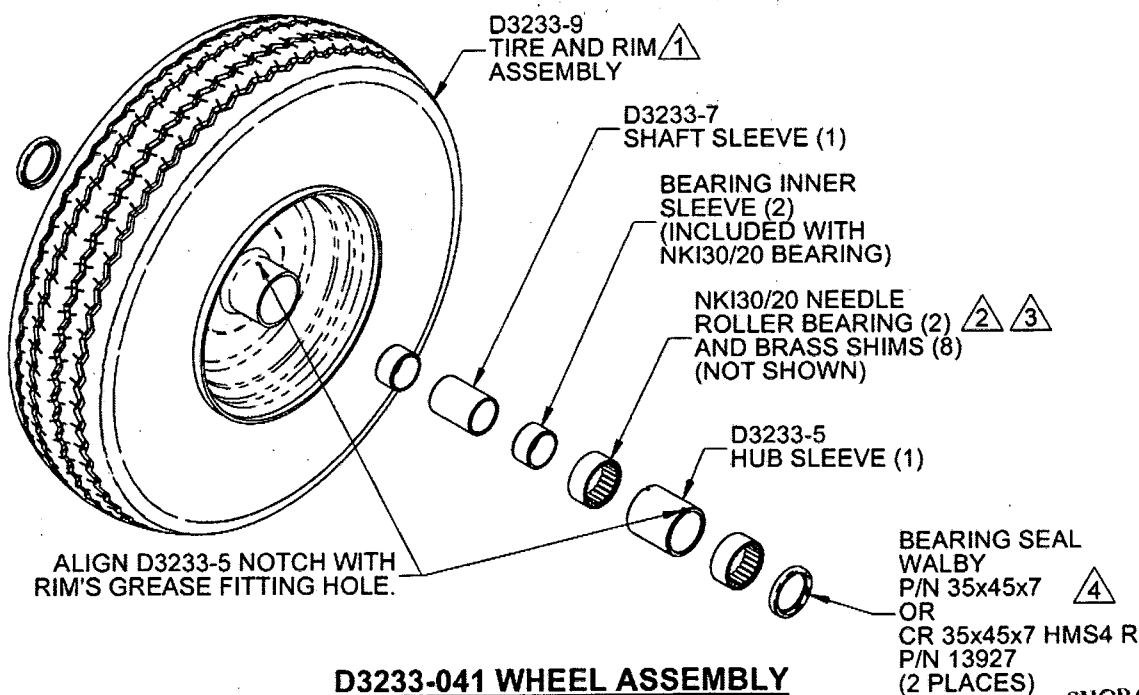
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3233	REV. B SHEET 1 OF 3
DATE 05.03.08	TITLE WHEEL ASSEMBLY		SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	



RELEASED
05/05/04

WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

* MANUFACTURER'S RECOMMENDATIONS ARE 75 PSI FOR HIGH SPEED USE.



D3233-041 WHEEL ASSEMBLY

NOTES:

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH (4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

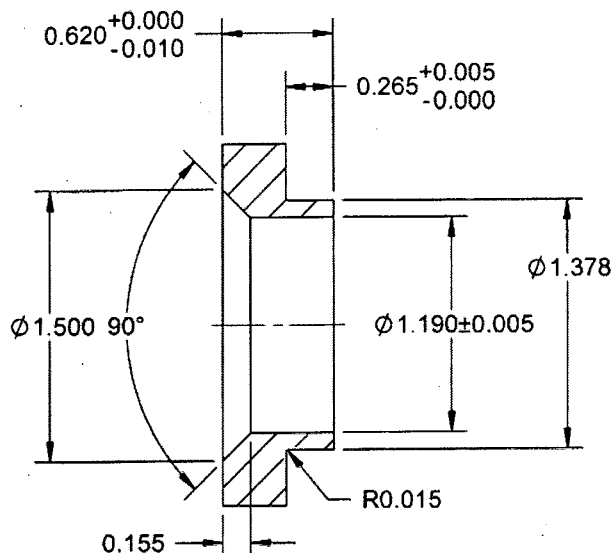
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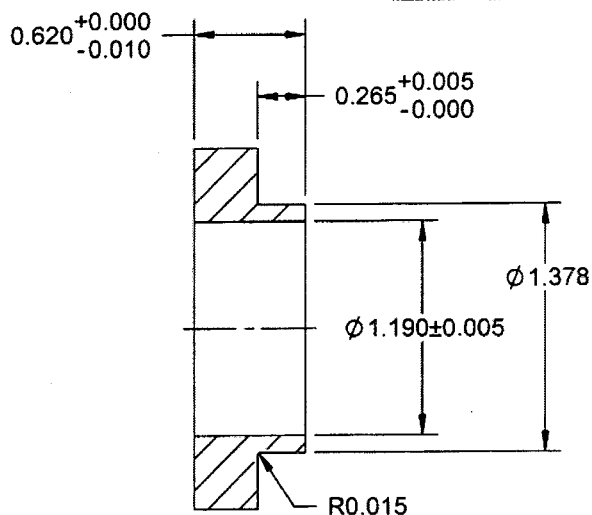
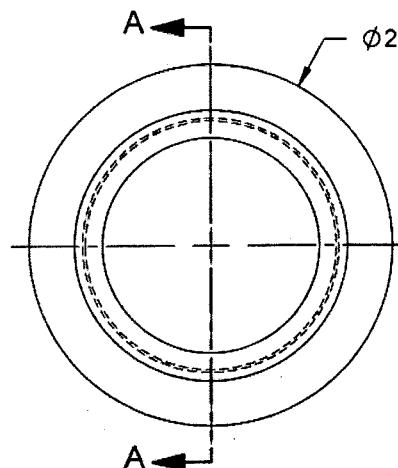


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DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1



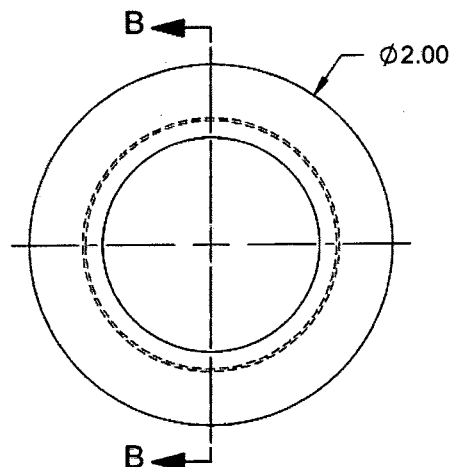
SECTION A-A

D3233-1 INSIDE WASHER



SECTION B-B

D3233-3 OUTSIDE WASHER



NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00, UNCONTROLLED COPY
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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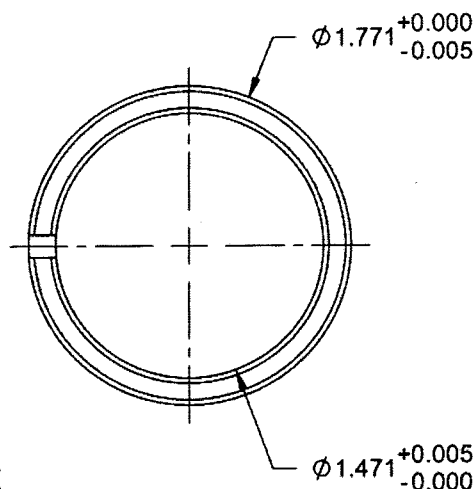
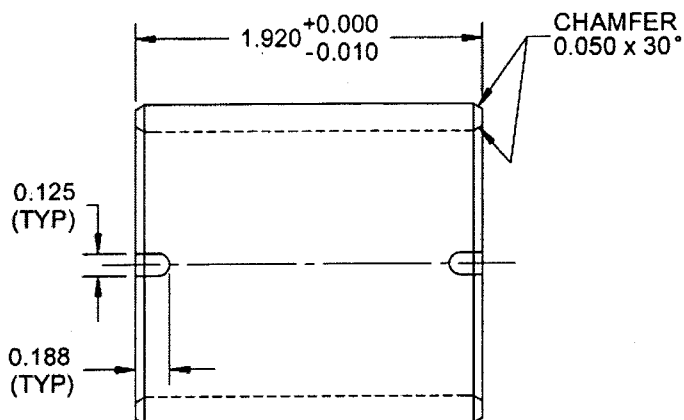
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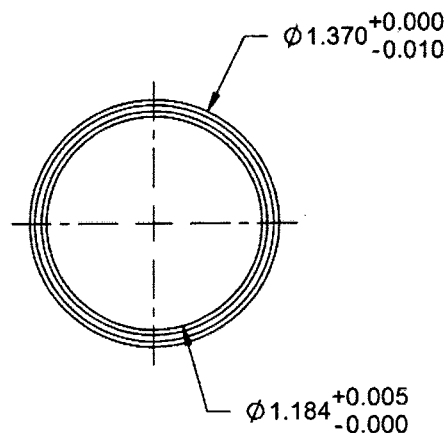
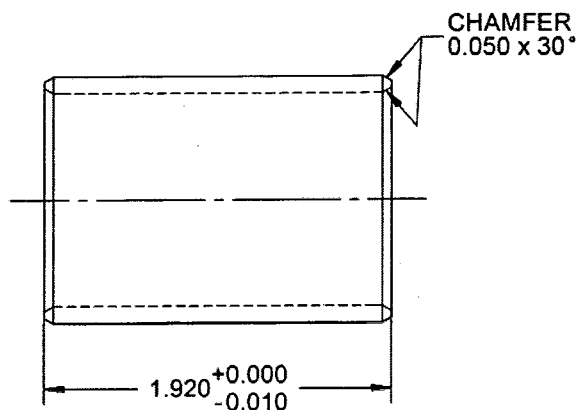


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DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1

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[Signature]
05/05/04



D3233-5 HUB SLEEVE



D3233-7 SHAFT SLEEVE

NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 UNCONTROLLED COPY
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR) SUBJECT TO AMENDMENT
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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NO. *43628*

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200 Aurora Industrial Pkwy
Aurora, OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada
Attention: Main Floor Shed Goods

Purchase Order
PO00007658

Page 1 of 1

McMaster-Carr Number
8659413-01

11/24/2008

Line	Description	Ordered	Shipped			
1	8353T74 Pneumatic Wheel with One-Piece Rim, 18" x 5.9", center Hub, 1-1/4" Axle, Roller Bearing, 1590 cap	10 Each	10			
				8 - 79 - 31	47 - 75 T74	10 EA 1
				152 lbs		152 lbs

Certificate of compliance

This is to certify that the above items were supplied in accordance with the description and as illustrated in the catalog.

Jason Wolfe
Compliance Manager

ON 3 Peps

Dart Aerospace Ltd

EXP

Cycle

30

152 lbs
1 line

FW1CFV36
11/24/2008
11:12/11:22
020



DART

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

Purchase Order

FXED
CLAVOIE

Date Nov 24, 2008	Page 1
Purchase Order Number PO00007658	

Vendor Address:

McMaster-Carr Supply Co,
P.O. Box 7690
Chicago, IL 60680-7690
USA
Phone (330) 995-5500
Fax (330) 995-9600

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VU-MCM001	Nov 24, 2008	N30	Purolator	Nov 28, 2008

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
10.0000	8353T74	TIRE & RIM Comments: AS PER I /NG D3233 REV. B MCMAST R P/N: 8353T74 B43628	28/11/2008	No	60.040000	Each	600.40

CERTIFICATE OF CONFORMITY
REQUIRED UPON DELIVERY

Comments:

Tax Summary:

Entered by: *CL* CLAVOIE

Approved By: *W*

Less: included tax	0.00
Subtotal	600.40
Total tax	0.00
Total purchase order in USD Dollars	600.40